

Work Order ID 69179

Wednesday, May 04, 2011 8:36:43 AM



Page 1

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 5/4/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: CZ Date: 11/05/04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"

Batch:

cut @ meter

CZ 11/05/04 100

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA927

DWG REV:

FOLIO REV:

(Check for crack while loading into the machine.)

2- deburr rough edges

7/10' 14001

issue 7/10 to meter

machine as per dwg D 2230-1

REV.G

CZ 11/05/04 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Lug					
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Required Date: 5/13/2011	Req'd Qty: 100.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2-Inspect parts off machine FAI/FAIB Memo rec'd + inspect for transit damage attached c/c to W10	0.00 0.00							
130 QC Quality Control	QC3-Inspect parts - second check Memo 8/11/05/30	0.00 0.00							
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							

Handwritten notes:

- 4/15/30
- counted 100
- QSP017
- 100 & 11-5-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Item Name: Lug

Start Date: 5/4/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

100x ~~QC~~ M-11/05/30

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:30
320 °F
4:00

100x ~~QC~~ M-11/06/01

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

100 — BR 11-6-2.

M116964

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 4

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Revision ID:

Stop



Item Name: Lug

Start Date: 5/4/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: S476

0.00



Packaging

Memo

0.00

Packaging

PS 11/06/03 (100)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/06/03
mf
11-06-03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 04, 2011 8:36:39 AM

Page 1

Work Order ID: 69179

Parent Item: D2230-1

Parent Item Name: Lug





Start Date: 5/4/2011

Required Date: 5/13/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP ☐ D ☐ 00.11.01 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423  Lug Extrusion		Manufactured	No			110	f	342.8400	0.0683	7.189474			
											CY 11/05/04		

Location

Loc Qty

Loc Code

MAT006

342.84

43722

161.5

45800

1

63005

180.34

7.19

D2230-1P

X100

104/5/30 (100)

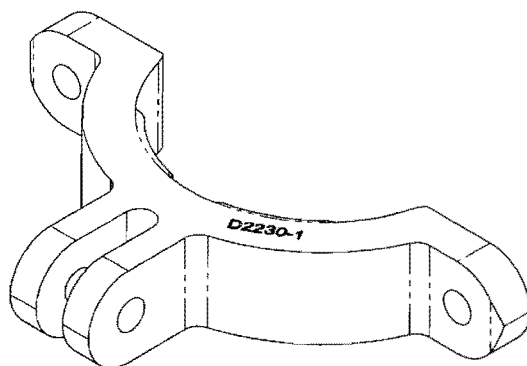
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

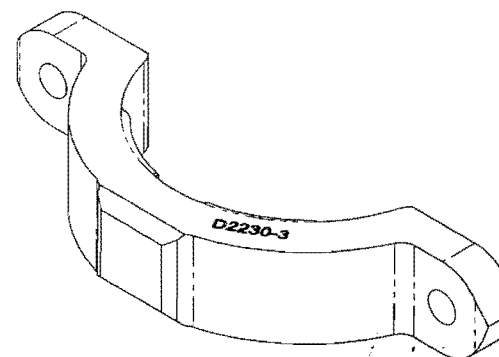
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

*CL 11/05/04
W10:69179*

RELEASED
09/01/16



NOTES:

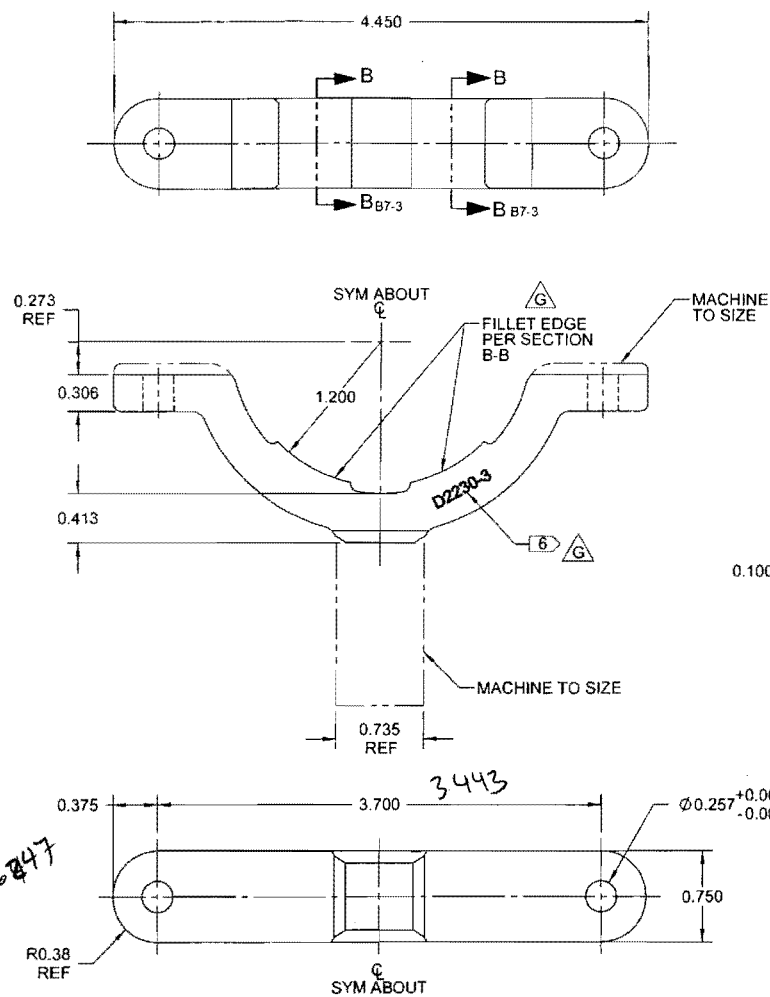
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015±0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV	DESCRIPTION	BY	DATE
DESIGN		BW	
DRAWN		AJS	
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2230	REV. G SHEET 1 OF 3
TITLE MOUNTING LUG	SCALE NTS
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SECTION B-B D4-3
SCALE 2X

R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

W/O: 69179

RELEASED
09/06/23M

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ALS		
CHECKED		DRAWING NO. D2230	REV. G
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		MOUNTING LUG	SCALE
DE APPR.			NTS
DATE	09.01.16	COPYRIGHT © 1984 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHO IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





Dart Aerospace Ltd.
1270 Aberdeen Street.
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14001

Purchase Order Date 5/4/2011

PO Print Date 5/4/2011

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Requisition Nbr	
Vendor Fax	613 678 3956	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D2731-7P		LUG	5/13/2011 Yes	36.00 Each	Dart Truck	\$13.9000	\$500.40
		Special Inst:	MACHINE AS PER DWG D2731 REV. C B69177				
D3394-3P		Lug	5/13/2011 Yes	36.00 Each	Dart Truck	\$18.9500	\$682.20
		Special Inst:	MACHINE AS PER DWG D3394 REV. B B69180				
D2230-1P		LUG	5/13/2011 Yes	100.00 Each	Dart Truck	\$18.9500	\$1,895.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B69179				

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

PO Total: \$3,077.60

Change Nbr: 1

Change Date: 5/4/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required where applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.:

17993

Date:

May 26, 2011

Page:

1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 14001	Sold By: Walz, Christian D.
Shipped By: your truck 17993	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-7 Lug Material supplied by DART: D2423 B63005	Each	36		
D3394-3 Lug Material supplied by DART: D2423 B63005	Each	36		
D2230-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100	100	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				

Received by _____

Thank you for your order!



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

100

D2230-1

Mounting Lug

14001

MATERIAL: supplied by DART D2423 B63005

11/15/10

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, May 26, 2011

